



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5770-7

Job Sheet 207412



Part No: D5770-7

Part Name: Lug

Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Job Qty: 8 pcs

DAS  
21  
9-89

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5570 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	8 pcs	3/6/20	3/6/20	1.00	0.40	SL-154 - 1		JB 20-02-28
110	QC 2	8 pcs	3/6/20	3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 20-02-28
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S259494



Part: D5770-7

Job No: 207412

Serial No/Batch: S259494

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 02/28/20

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie



120	QC 8	8 pcs	3/6/20	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

m/20/02/29

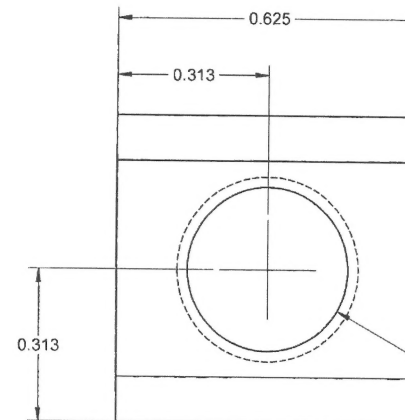
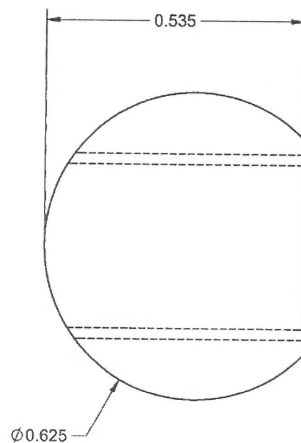
DAS  
24  
9-89



				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op <b>100</b> - 1-Machine as per folio FD183 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Debur Descriptions: <b>110</b> - QC2- Inspect parts off machine FAI/FAIB <b>120</b> - QC8- Inspect parts - second check <b>130</b> - (Identify as per dwg & Stock Location: _____). See note 6. <b>140</b> - (QC21- Final Inspection - Work Order Release)					
<b>Job BOM</b>					
<b>Part / Item</b>	<b>Component Name</b>	<b>Quantity</b>	<b>Operation</b>	<b>Container</b>	
M1018R0.750	M1018R0.750	.5566 ft (.06958 ea)	100-SL-154 - 1	5000799	
<b>Job Allocations</b>					
<b>Operation</b>	<b>Component Part</b>	<b>Required</b>	<b>Inventory</b>	<b>Allocated</b>	
100-SL-154 - 1	M1018R0.750	1	26	0	
<b>Part Specifications</b>					
Specifications could not be found.					

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie





**D5770-7 LUG**  
(DERIVED FROM AERO DESIGN P/N 69823-02)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 207412 MJS

2002-26

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: AISI 1018/1025 STEEL ROUND BAR  
PER MIL-S-7097 OR ASTM A108  
REF DART SPEC M1018-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.04 lbs

**RELEASED**

2020 FEB 18 *NO*

APPROVED

DESIGN ZF  
DRAWN ZF  
CHECKED KPT  
MFG. APPR. DD  
APPROVED NO  
DE APPR. CP  
DATE 20.01.09

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D5770**

TITLE

**BASKET HOOPS**

REV. A

SHEET 6 OF 7

SCALE

NTS

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Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

## PURCHASE ORDER PO37858

**Supplier:** ACI001-VC  
Acier Ouellette Inc.  
935 Boul. Du Havre  
Valleyfield  
QC  
J6S 5L1 Canada  
Phone: 800 667 4248  
Fax: 450 377 5696

**PO No:** PO37858  
**PO Date:** 9/25/17  
**Due Date:** 10/6/17  
**Purchase Order**  
**Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Pymt Terms:** net 30  
**Freight Terms:**  
**Special Comments:**

Items											
Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	M1018R2.250	-	M1018R2.250 : MATERIAL: AISI 1018-1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	3 ft	0 ft 3x	3 ft	\$12.206666/ft	\$36.62
2	M1018R0.750	-	M1018R0.750 : MATERIAL: AISI 1018-1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	20 ft	0 ft 2x B.11	20 ft	\$1.169/ft	\$23.38
3	M1018B1.000X06.000	-	1010-1025 Steel Bar 1.000 X 6.000 : MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40-21 38W/44W/50W/60W/70W CSA G40-21 OR 38W/44W/50W/60W/70W		Firmed	10/6/17	6 ft	0 ft 6x	6 ft	\$30.42/ft	\$182.52
4	M304R.500	-	304 SS roundbar .500 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE		Firmed	10/6/17	36 ft	0 ft 36x	36 ft	\$1.9072222/ft	\$68.66
5	M6061T6R1.375	-	6061-T6 Round Bar 1.375" : MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117 4128/4115/4116 OR QQ-AA-200/8 OR AMS-QQ-A-		Firmed	10/6/17	12 ft	0 ft 12x	12 ft	\$5.6841666/ft	\$68.21





## DELIVERY - CLIENT

CO00053066

**ACIER OUELLETTE INC.**

935, Boul. du Havre  
Salaberry de Valleyfield (Québec) J6S 5L1  
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248  
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Customer N° CLI0001056  
Date 2017/09/25  
Delivery date **2017/10/06**  
Your order N° 37858  
Processed by Josianne Bourdon  
Salesman  
Carrier OUELLETTE VALLEYFIELD  
Credit Terme Net 30 Days  
Page 1

**Billed to**

DART AEROSPACE LTD  
1270 , ABERDEEN ST.  
HAWKESBURY, Ontario, K6A 1K7

**Shipped to**

, Ontario,

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Instruction F-M

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 ROUND CR 2 1/4 1018 RANDOM RCR-214-V 5301 1 X 36" HEAT: 136550 COUPE A LA SCIE SCIE 1 DAS 5 9-89	40.56	3.00	PI_\$CLB								
2 ROUND CR 3/4 1018 RANDOM RCR-34-V 5332 1 X 20' R/L HEAT: 139625 DAS 5 9-89	30.00	20.00	PI_\$CLB								
3 FLAT CR 1 X 6 1018 RANDOM FCR-16-V 2775 1 X 6' HEAT: 3066812	122.40	6.00	PI_\$CLB								

NIR : R-109516-6

Next Page...



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K6A 1K7  
Canada

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**Supplier:** ACI001-VC  
Acier Ouellette Inc.  
935 Boul. Du Havre  
Valleyfield  
QC  
J6S 5L1 Canada  
Phone: 800 667 4248  
Fax: 450 377 5696

**PO No:** PO37858  
**PO Date:** 9/25/17  
**Due Date:** 10/6/17  
**Purchase Order**  
**Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Pymt Terms:** net 30  
**Freight Terms:**  
**Special Comments:**

### Items

Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	MT-HRS-P-0.3125		Hot Rolled Steel Plate 0.3125" (44W)		Firmed	10/6/17	16 ft	0 ft	16 ft	\$9.05/ft	\$144.80
13	M4140H-R0.500		4140 round bar 0.500"		Firmed	10/6/17	12 ft	0 ft	12 ft	\$2.85/ft	\$34.20

**Grand Total:** \$179.00

### Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)  
A026 certification of material conformance  
A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 10/18/17 3:59 PM Dart.baker.diane





ARANA Y LUPARDO, 2  
48490 UGAO-MIRAVALLS/VIZCAYA (SPAIN)  
Tfno.: 946480211  
Fax: 946480128  
Email: calpradera@calibradospradera.es  
www.calibradospredem.es

## CERTIFICADO DE CALIDAD/QUALITY REPORT

De acuerdo a /Made according to:

EN 10204/DIN 50049

3.1

Nº CERTIFICADO / CERTIFICATE NR: 47862

ALBARAN 47862  
Delivery Note Nr.

CLIENTE LES ACIERS TRANSBEC (1997) LTÉE  
CUSTOMER

Norma : EN 10277

Productos Calibrados de acero. Condiciones técnicas de suministro.

Norm :

Bright steel products. Technical delivery conditions.

MEDIDA Measurement	OF	COLADA Cast Nr.	Resistencia Tens. strength N/mm <sup>2</sup>	Lím.elástico Yield point 0,2% N/mm <sup>2</sup>	Alargamiento Elongation Lo=50 mm	Dureza HB Hardness HB	Estricción %
25,40	202437	41300 AG	556,11	543,10	19,46	159,00	46,32
25,00	139261	41403 G	558,02	541,20	18,34	169,00	61,11
25,00	139283	41403 G	558,02	541,20	18,34	169,00	61,11
12,70	137659	41136 AA	512,37	482,16	13,80	169,00	60,12
31,75	136439	40201	510,00	370,00	22,00	0,00	0,00
15,88	916391	40619 AA	579,16	547,66	19,70	169,00	58,82
19,05	139479	41379 AA	611,80	592,66	18,78	180,00	63,05
12,70	137659	41136 AA	512,37	482,16	13,80	169,00	60,12
19,05	139625	41379 AA	611,80	592,66	18,78	180,00	63,05
9,53	915990	40828 G	783,23	761,48	10,92	247,00	0,00
15,88	916216	40619 AA	574,47	549,90	20,16	162,00	64,21
6,35	915673	40073 G	822,40	791,50	7,94	258,00	47,07
7,94	916609	41174 GM	754,80	715,70	12,24	216,00	58,26
22,23	139773	41472 AG	573,78	552,34	25,92	172,00	57,86
15,88	916509	41252 AA	622,39	607,75	12,72	200,00	48,37
25,40	202437	41300 AG	556,11	543,10	19,46	159,00	46,32
28,58	916104	40910 G	568,80	546,30	32,76	169,00	59,00
22,23	139824	41472 AG	573,78	552,34	25,92	172,00	57,86

Calidad Superficial

DESCRIPCIÓN Description	OF	Clase EN 10277-1
12L14 RED. ESTIRADO 25,40 (1")	202437	3
1018 RED. ESTIRADO 25,00	139261	2
1018 RED. ESTIRADO 25,00	139283	2
12L14 RED. ESTIRADO 12,70 (1/2")	137659	3
1018 RED. ESTIRADO 15,88 (5/8")	916391	2
1018 RED. ESTIRADO 19,05 (3/4")	139479	2
12L14 RED. ESTIRADO 12,70 (1/2")	137659	3
1018 RED. ESTIRADO 19,05 (3/4")	139625	2
1018 RED. ESTIRADO 15,88 (5/8")	916216	2
1018 RED. ESTIRADO 7,94 (5/16")	916609	2
1018 RED. ESTIRADO 22,23 (7/8")	139773	2
12L14 RED. ESTIRADO 15,88 (5/8")	916509	3
12L14 RED. ESTIRADO 25,40 (1")	202437	3
1018 RED. ESTIRADO 28,58 (1 1/8")	916104	2
1018 RED. ESTIRADO 22,23 (7/8")	139824	2



ARANA Y LUPARDO, 2  
48490 UGAO-MIRAVALLS/VIZCAYA (SPAIN)  
Tfno.: 946480211  
Fax: 946480128  
Email: calpradera@calibradospradera.es  
www.calibradospradera.es

## CERTIFICADO DE CALIDAD/QUALITY REPORT

De acuerdo a /Made according to:

EN 10204/DIN 50049

3.1

Nº CERTIFICADO / CERTIFICATE NR.: 47862

ALBARAN 47862 Delivery Note Nr.	CLIENTE LES ACHIERS TRANSBEC (1997) LTÉE CUSTOMER
------------------------------------	--

Norma : EN 10277

Productos Calibrados de acero. Condiciones técnicas de suministro.

Norm :

Bright steel products. Technical delivery conditions.

Observaciones: BARRAS DE ACERO ESTIRADAS EN FRIO SIN ALEAR

DEPARTAMENTO DE CALIDAD: Certifica que el mencionado producto cumple con las especificaciones del pedido.

QUALITY DEPARTMENT: Certify that the product fulfils the order specifications.

Fecha/Date: 19/06/2017

Firmado: Susana Fernández  
Directora de Calidad



Sistema de  
Gestión  
ISO 9001:2008

www.tuv.com  
EN 10204:2004